

Date: Friday, 23/03/2007 8:25:45 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 31446	
Estimate Number : 12579	
P.O. Number : N/A	Part Number : D35602
This Issue : 23/03/2007 S.O. No. : N/A	Drawing Number : D3560 UNDER REVIEW <i>for replacements</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30538	Material : SHA
Written By : _____	Due Date : 26/03/2007 Qty: 3 Um: Each
Checked & Approved By : <i>Le</i>	
Comment : Est Rev. A New Issue 06-11-10 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.0080 f(s)/Unit Total : 3.0240 f(s)

6061-T6 Bar .50" x 6.0"

Batch: *M 101919* ~~W 101919~~ *ML 07 03 23* (3)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: *A*

Prsg Rev: *A* *ML 07 03 23* (3)

2-Deburr if necessary

Note: .507" Dia & .196" Dia Holes are to be opened on manual mill after Waterjet

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE *ML 07 03 23* (3)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

Ensure to C'Bore on Corect side *MS 07/03/23* (3)

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Drawing Name: ARM

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/03/26 (3)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/03/26 (3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WPA*

P.L. 07-03-26 (3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

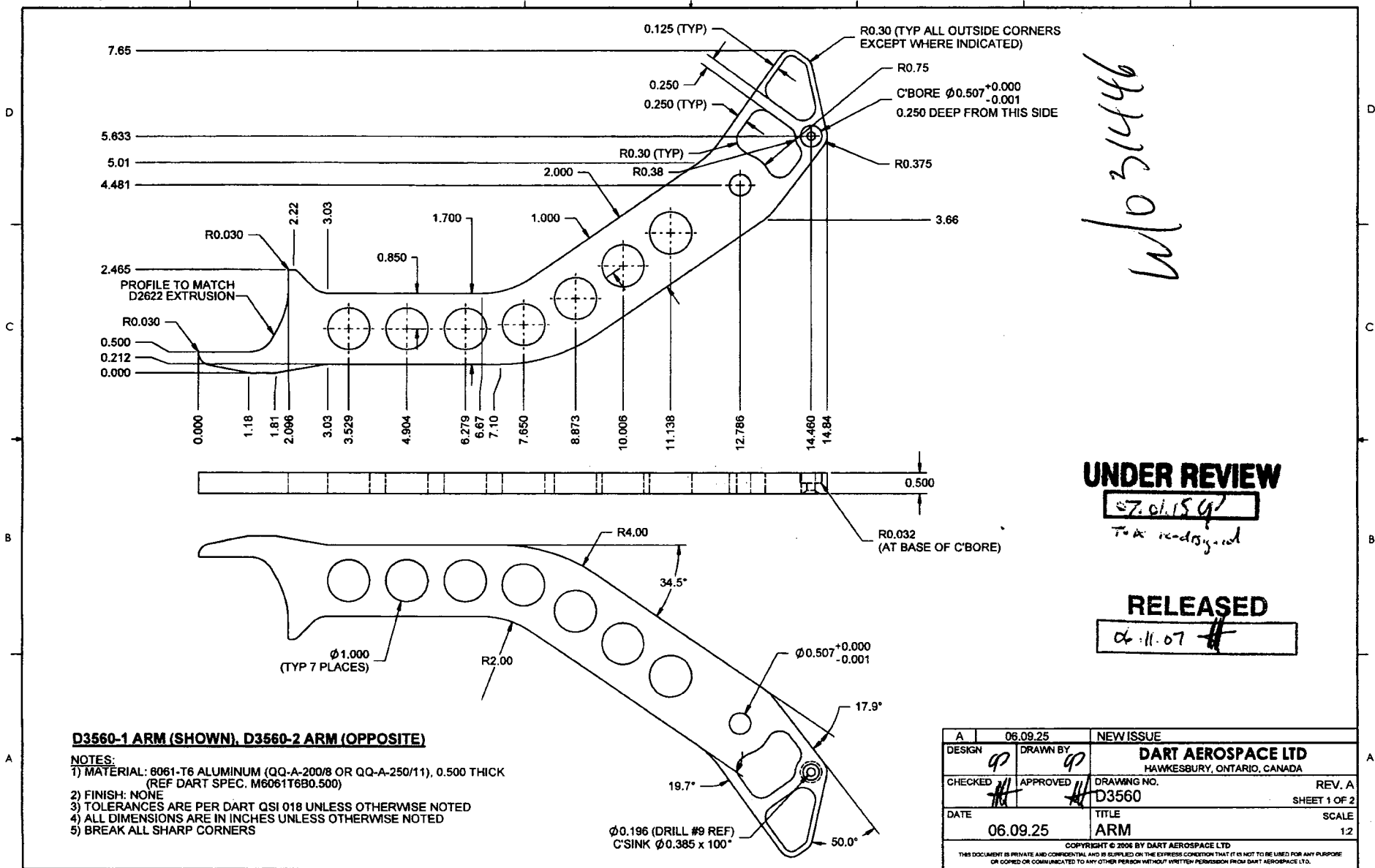
P.L. 07/03/26

Job Completion

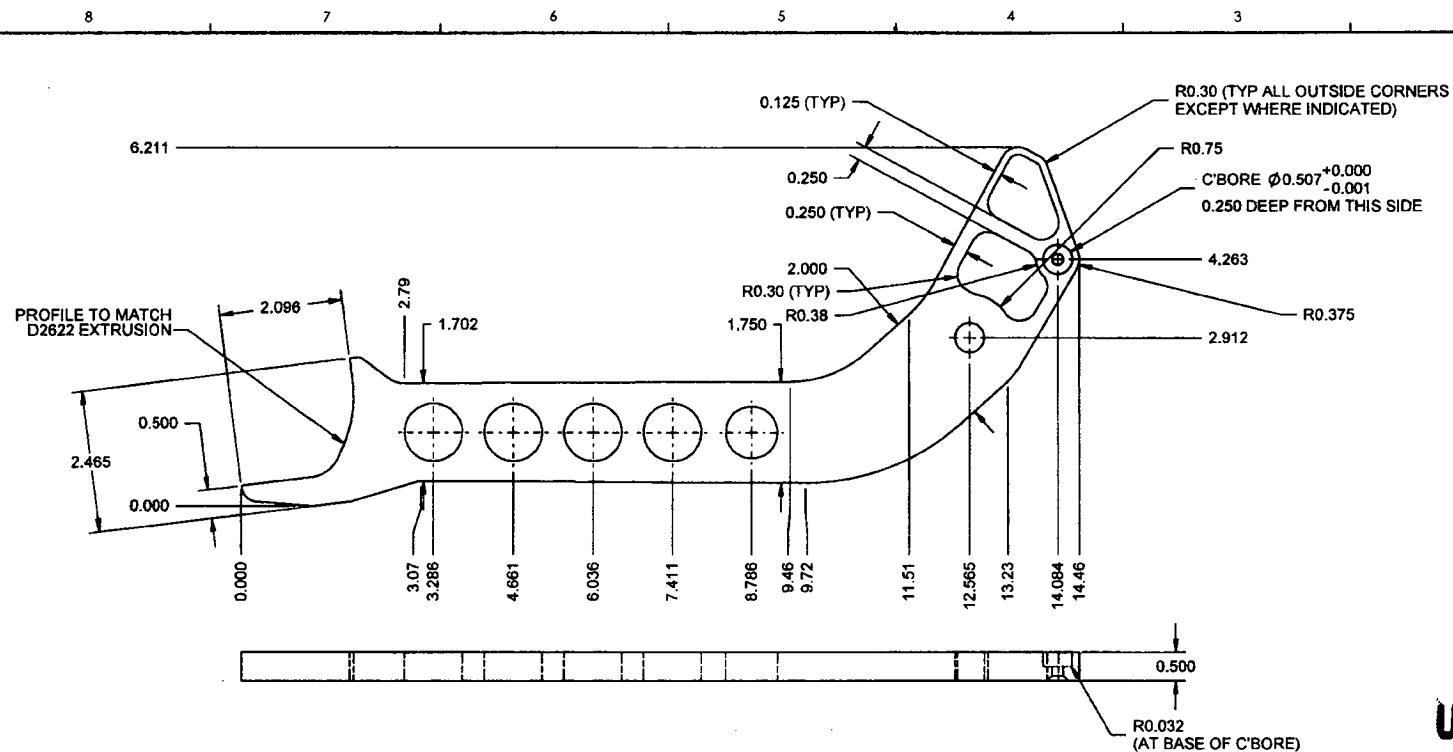


07 03 26

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



UNDER REVIEW
07.11.07 CP

RELEASED
06.11.07

D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11), 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	06.09.25	DRAWING NO.	REV. A
		D3560	SHEET 2 OF 2
		TITLE	SCALE
		ARM	1:2
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DART AEROSPACE LTD		Work Order: 31446
Description: ARM		Part Number: D3560-2
Inspection Dwg: D3560 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 1.000	+0.012-0.001	1.000	✓		vern	
B	Ø 0.507	+0.008-0.001	0.507	✓		vern	
C	Ø 0.196	+0.005-0.001	0.201	✓		vern	
D	0.500	+/- 0.010	0.503	✓		vern	
E	0.465	+/- 0.010	2.465	✓		vern	
F	0.250	+/- 0.010	0.249	✓		vern	
G	0.125	+/- 0.010	0.125	✓		vern	
H	2.000	+/- 0.010	2.000	✓		vern	
I	1.700	+/- 0.010	1.701	✓		vern	
J	0.850	+/- 0.010	0.852	✓		vern	
K	1.000	+/- 0.010	1.000	✓		vern	
L	.507	+ .000 - .001	.507	✓			
M	.385 x 1000	+ .010	.385	✓			
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: ml. ml	Audited by:	Prototype Approval:	N/A
Date: 07 03 23	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	